

Date: Friday, 23/05/2008 9:53:10 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|--------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | BELL CRANK |
| Job Number : | 39434 | | |
| Estimate Number : | 11967 | | |
| P.O. Number : | | Part Number : | D2056 |
| This Issue : | 23/05/2008 | Drawing Number : | D2056 REV B2 |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | / / | Drawing Revision : | B2 |
| Previous Run : | 37727 | Material : | |
| Written By : | | Due Date : | 15/06/2008 |
| Checked & Approved By : | JUL 08.5.23 | Qty: | 30 |
| Comment : | Est. E 02.04.04 Added Rev.B2 NG | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------------|--------------------------|
| 1.0 | M6061T6B1250X01250 | 6061-T6 Bar 1.25 x 1.25" |
|-----|--------------------|--------------------------|



Comment: Qty.: 0.2494 f(s)/Unit Total : 7.4813 f(s)

6061-T6 Bar 1.25 x 1.25"

Material: 6061-T6, 1.250" x 1.250"

Batch: M107744 *ml 08/06/21* (30)

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut blanks 2.80" long

ml 08/06/21 (30)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2056

Tumble

Deburr any rough edges after tumbling

ml 08/06/21 (30)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/06/21 (30)

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

S 08/06/23 (30) *counter*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:53:10 AM
User: Julie Lecoq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL CRANK

Job Number: 39434

Part Number: D2056

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 08/06/23

30X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

7:35

OVEN TEMPERATURE:

320°

FINISH TIME:

8:05

FL 08/06/24

(30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/06/24

(30X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 10*

AS 08/06/25

(X30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



mf 08-06-25

Dart Aerospace Ltd

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NOTE: Date & initial all entries

| | | |
|--------------------------------|----------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 39434 |
| Description: Bell Crank | | Part Number: D2056 |
| Inspection Dwg: D2056 | Rev: B2 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.750 | +/-0.010 | .750 | ✓ | | | |
| 0.900 | +/-0.010 | .900 | ✓ | | | |
| 1.000 | +/-0.010 | 1.001 | ✓ | | | |
| 0.125 | +/-0.010 | .126 | ✓ | | | |
| 0.060 | +/-0.010 | .061 | ✓ | | | |
| Ø0.191 | +0.005/-0.001 | .191 | ✓ | | | |
| 0.362 | +/-0.010 | .365 | ✓ | | | |
| 0.750 | +/-0.010 | .750 | ✓ | | | |
| 0.385 | +/-0.010 | .385 | ✓ | | | |
| Ø0.257 | +0.006/-0.001 | .260 | ✓ | | | |
| 0.100 | +/-0.010 | .100 | ✓ | | | |
| 0.300 | +/-0.010 | .300 | ✓ | | | |
| 0.946 | +/-0.010 | .946 | ✓ | | | |
| 0.750 | +/-0.010 | .750 | ✓ | | | |
| 0.075 | +/-0.010 | .075 | ✓ | | | |
| 2.637 | +/-0.010 | 2.637 | ✓ | | | |
| 0.375 | +/-0.010 | .375 | ✓ | | | |
| Ø0.513-0.518 | 0.513 - 0.518 | .518 | ✓ | | | |
| R0.450 | +/-0.010 | .450 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| R0.200 | +/-0.010 | .200 | ✓ | | | |
| R0.550 | +/-0.010 | .550 | ✓ | | | |
| R0.263 | +/-0.010 | .263 | ✓ | | | |

| | | | |
|--------------------------|-------------------------|----------------------------|-----|
| Measured by: J.L. | Audited by: J.P. | Prototype Approval: | N/A |
| Date: 08/06/20 | Date: 08/06/21 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.04.11 | New Issue | KJ/DD | |

Dart Aerospace Ltd

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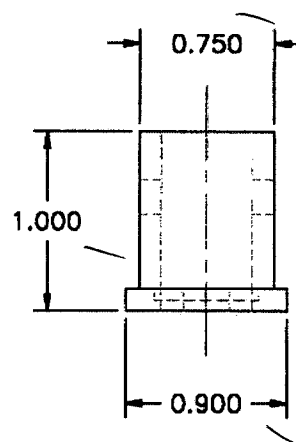
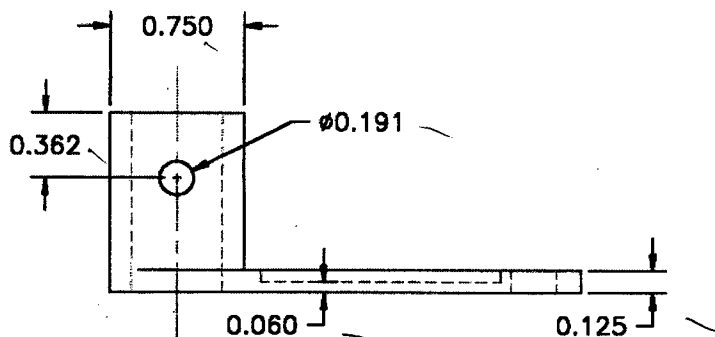
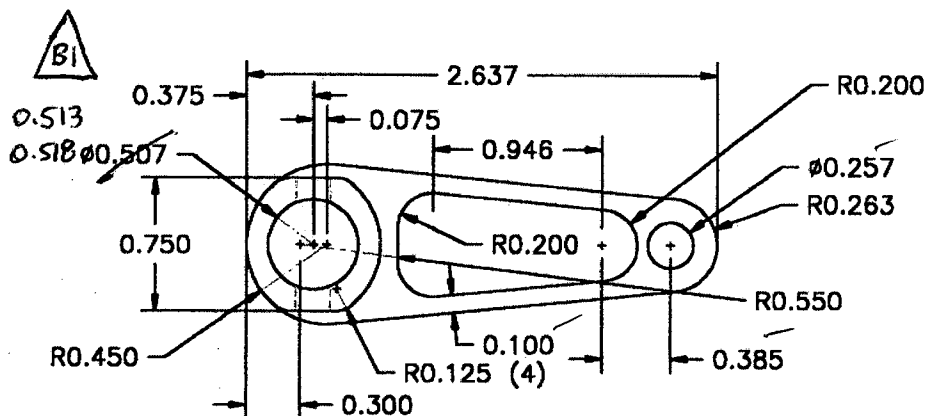
NOTE: Date & initial all entries

DART



RELEASED
99.04.28 HFE

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|------------|------------|--|
| B WILLIAMS | K HAND | VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| <i>HFE</i> | <i>HFE</i> | D2056 |
| DATE | TITLE | SHEET 1 OF 1 |
| 92:03:13 | BELL CRANK | SCALE 1:1 |
| B | 95:11:02 | RE-DESIGN |
| B1 | 01.06.04 | MODIFY HOLE SIZE, ADD FIL CPTN |
| B2 | 01.12.20 | ADD NOTE ON TOLERANCES |



B1 ACID ETCH & ALDINE PER
DART QSI 005 4.1
POWDER COAT BLACK SHIMMER
(4.3.5.7) PER DART
QSI 005 4.3

MATERIAL: 6061-T6 (QQ-A-225/B)
FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39434

| W/O: | | WORK ORDER CHANGES | | | | | |
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